

The listing of the claims will replace all prior versions, and listings, of claims in the application:

**Listing of Claims:**

Claim 1 (currently amended).

Method for the production of a cooled ring insert (1), consisting of a gray casting alloy having a nickel content, for an aluminum piston of an internal combustion engine, to be produced using the casting method, having a cooling channel (6) formed on the ring insert back (3), as a turned groove (4) that is open towards the bottom, ~~characterized by~~ comprising the following steps:

- salt granulate is pressed into the turned groove (4) at a pressure of 100 to 300 N/mm<sup>2</sup>, so that a salt core (5) is formed in the turned groove (4);
- the combination consisting of the ring insert (1) and the salt core (5) is pre-heated to a temperature of 200°C to 250°C;
- the combination consisting of the ring insert (1) and the salt core (5) is dipped into an alfin bath consisting of an aluminum melt.

Claim 2 (currently amended).

Method for the production of a cooled ring insert (1) as recited in claim 1, ~~characterized in that~~ wherein the combination

consisting of the ring insert (1) and the salt core (5) combination is dipped into an alfin bath consisting of an aluminum melt for 2½ to 5½ minutes.

Claim 3 (currently amended).

Method for the production of a cooled ring insert (1) as recited in claim 1 ~~or 2, characterized in that~~ wherein a finished, pressed salt core (5) is placed into the turned groove (4), and attached in the holder (4) by means of an adhesive bond.